

Friday, October 07, 2016 2:33:07 PM

151698

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 10/5/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 10/7/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *VS* *(1/1)* Date: *16/10/11*

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
-----------------	---------------------

D3259 Rev B

100

0.21

100

FLOW WATER JET

0.08

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3259

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

Work Order ID 151698

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Item ID: D3259-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer
 Start Date: 10/5/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/7/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				4			DAS 38 OCT 25 2016
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.05				(x4)			2016/10/25 BEB
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				(4)			DAS 38 9-28 OCT 25 2016

Work Order ID 151698

151698

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Friday, October 07, 2016 2:33:07 PM

Item ID: D3259-5 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Spacer
Start Date: 10/5/2016 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 10/7/2016 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
150									
Packaging	Memo	0.01							
Packaging	LOCATION : <i>GA</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.07							
Quality Control									

DAS
21
9-89

OCT 25 2016

Picklist Print

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Page 1

Work Order ID: 151698

151698

Parent Item: D3259-5

D3259-5

Parent Item Name: Spacer

Start Date: 10/5/2016

Required Date: 10/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	106.0000	1.388	5.844210			

M2024T3S 032

2024-T3 .032 sheet

du 16/10/23

Location

Loc Qty

Loc Code

MAT022

106

M133452

13.2

M134581

2.8

M135010

25.6

M135032

64.4

1.5
4.3

DART AEROSPACE LTD		Work Order: 151698
Description: Spacer		Part Number: D3259-5
Inspection Dwg: D3259 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

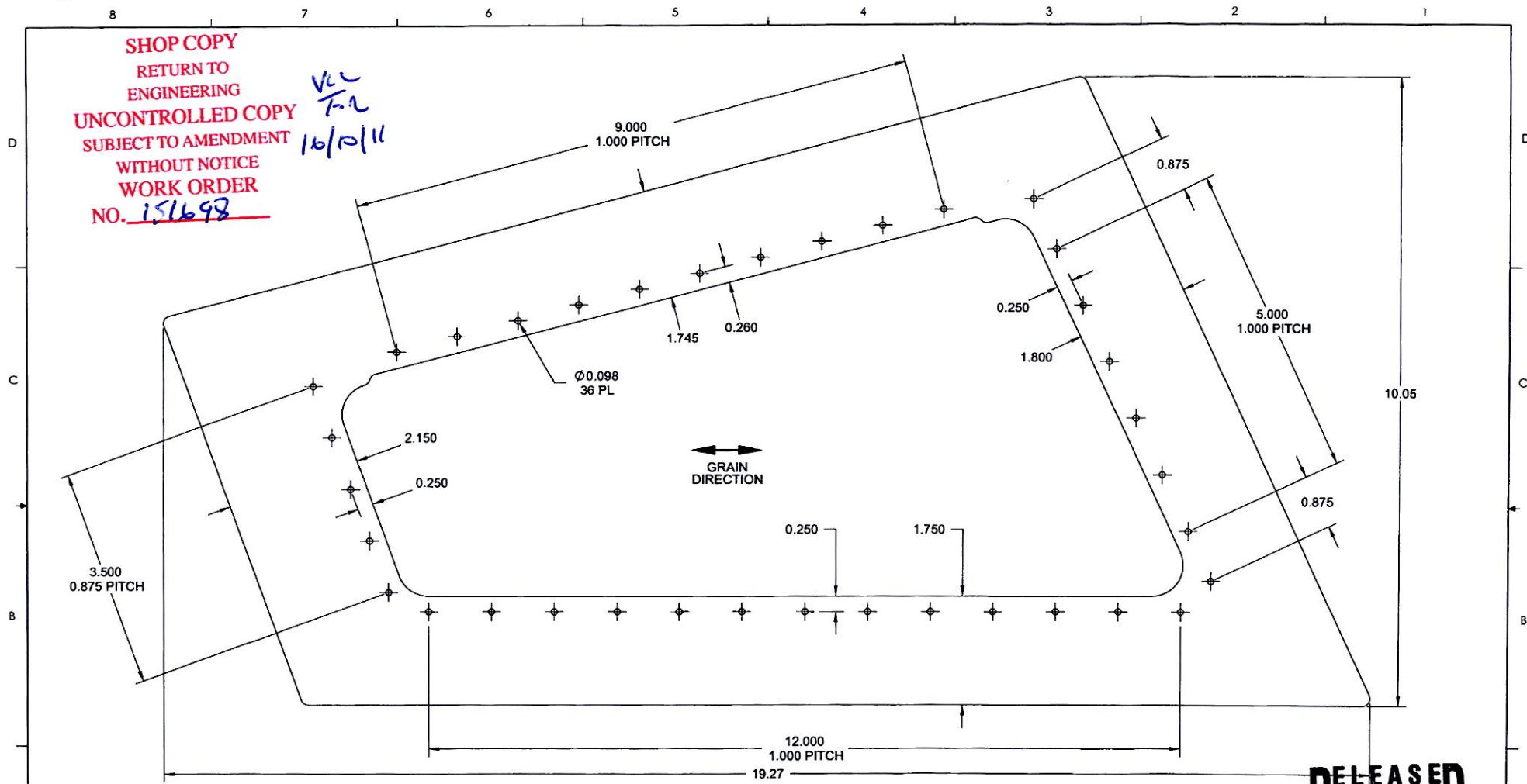
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	9.003	1		V=2-02	
1.000	+/-0.005	1.004	1			
5.000	+/-0.005	5.002	1			
12.000	+/-0.005	12.004	1			
3.500	+/-0.005	3.502	1			
0.875	+/-0.005	.878	1			
0.260	+/-0.010	.265	1			
R0.50	+/-0.030	.50	1			
0.250	+/-0.010	.253	1			
0.875	+/-0.005	.879	1			
Ø0.098	+0.005/-0.000	Ø.101	1			
0.550	+/-0.010	.559	1			
R0.50	+/-0.030	.50	1			
10.062	+/-0.010	—	1			
R0.13	+/-0.030	.13	1			
0.032 thick	+/-0.010	.031	1			
0.130	+/-0.010	—	1			

Measured by: <u> DC </u>	Audited by: <u> DAS 38 </u>	Preliminary Approval:
Date: <u> 10/10/23 </u>	Date: <u> OCT 25 2016 </u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151698

VLC
T-2
16/10/11

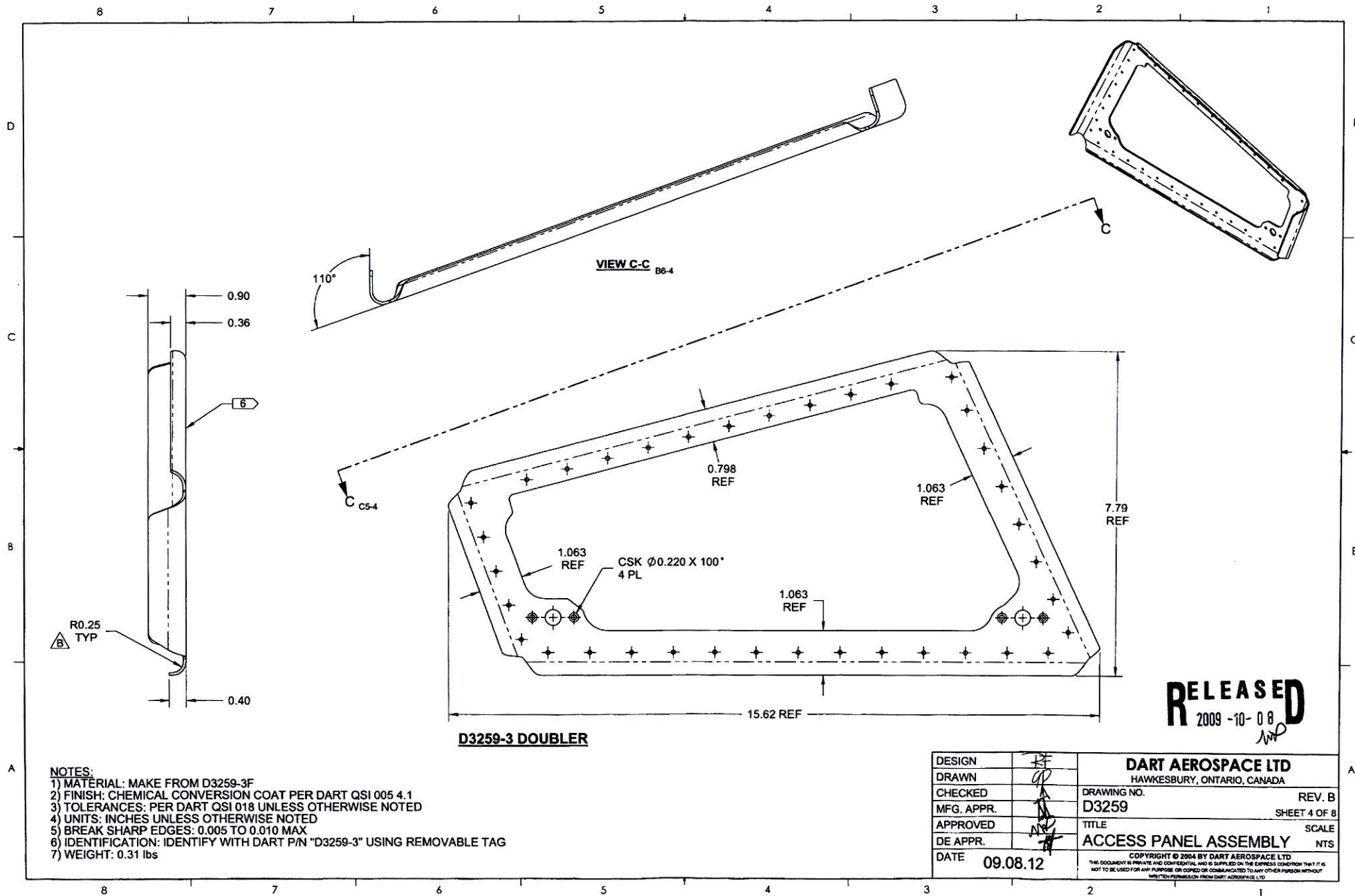


D3259-1 PANEL

RELEASED
2009-10-08
JMO

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
 - 7) WEIGHT: 0.25 lbs
 - 8) MAKE PER DWG FILE "D3259-1B.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3259	REV. B
MFG. APPR.		TITLE	SHEET 3 OF 8
APPROVED		ACCESS PANEL ASSEMBLY	SCALE
DE APPR.			NTS
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

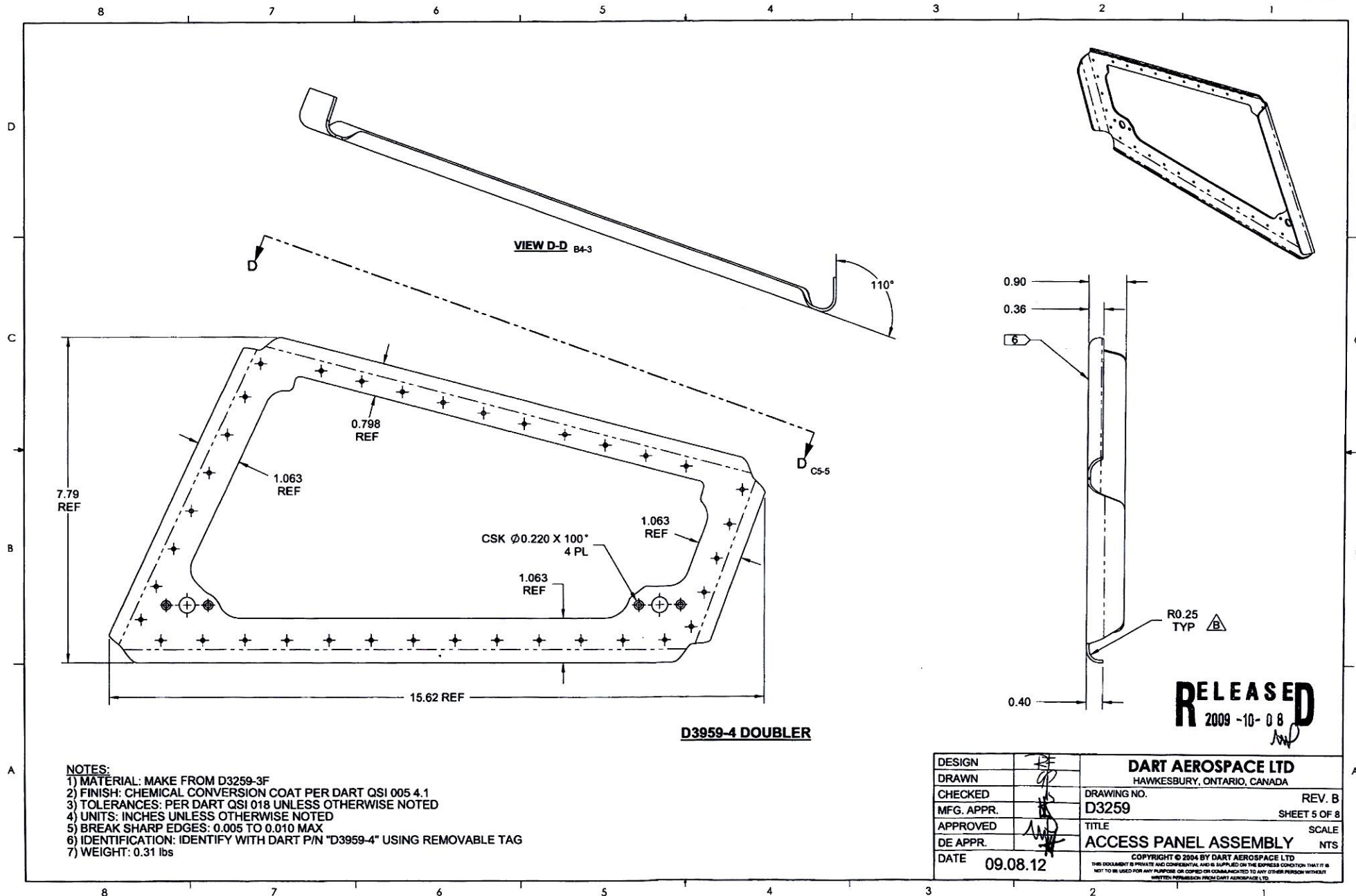


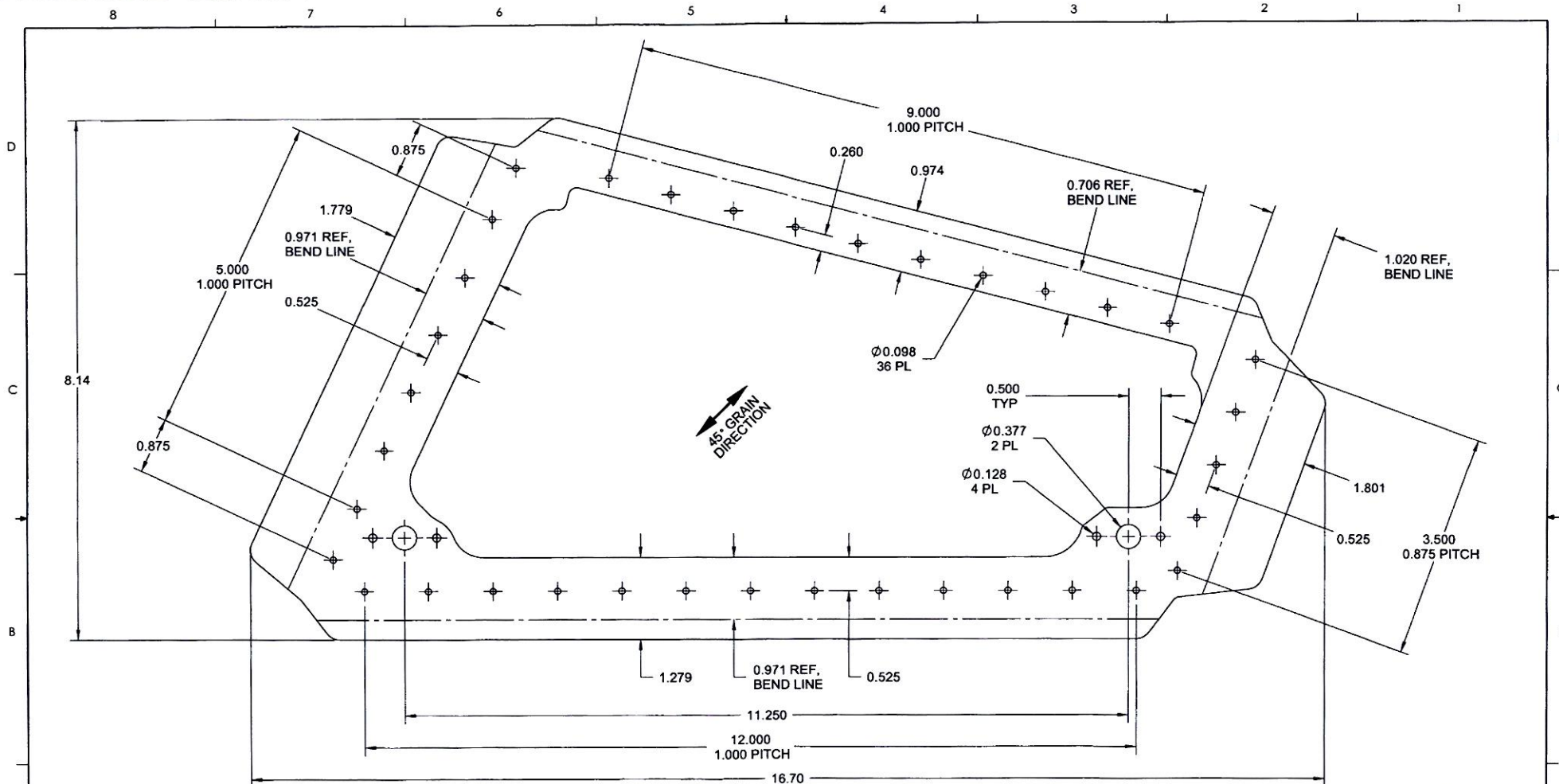
D3259-3 DOUBLER

- NOTES:**
- 1) MATERIAL: MAKE FROM D3259-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3" USING REMOVABLE TAG
 - 7) WEIGHT: 0.31 lbs

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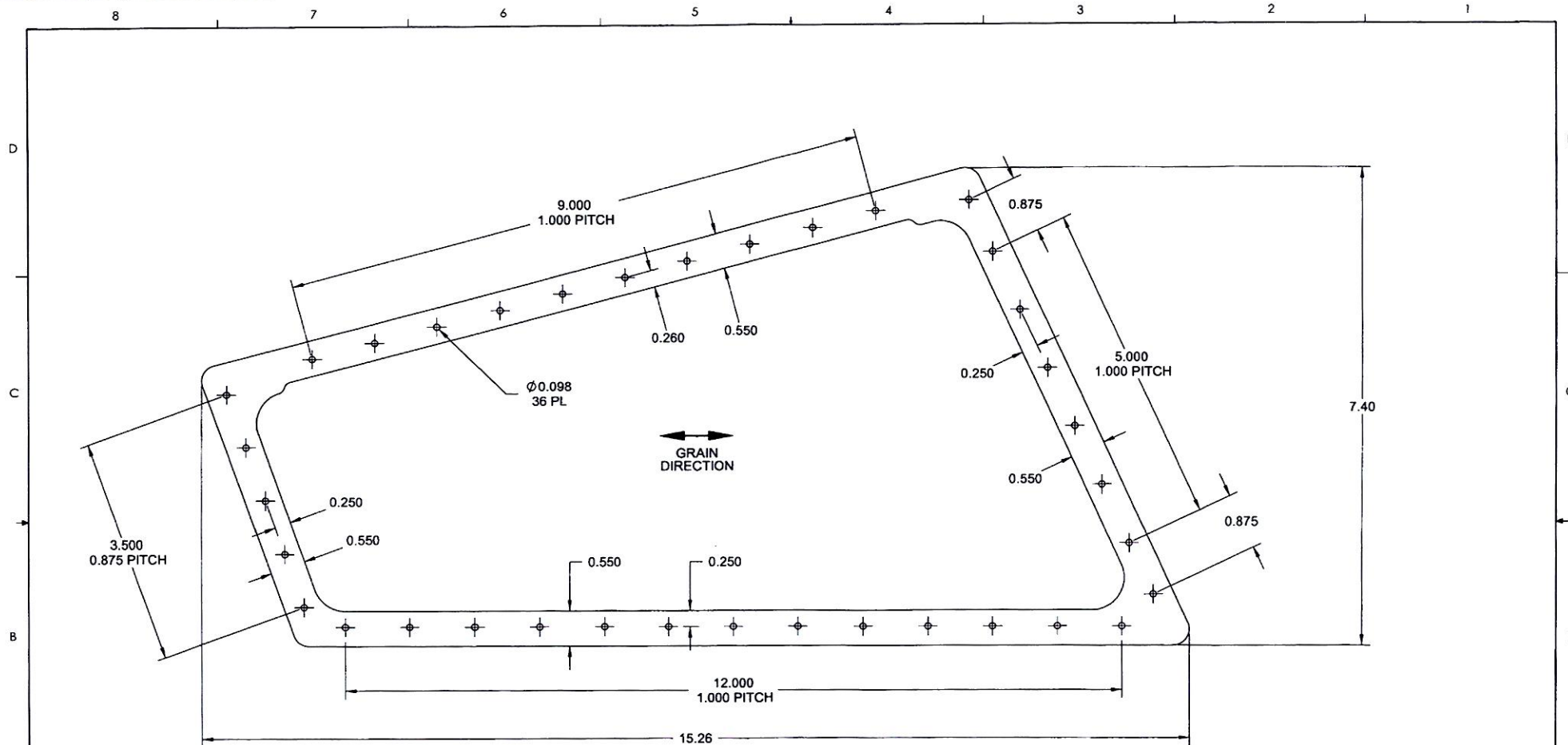
D3259-3F DOUBLER

RELEASED
2009 -ic- 08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

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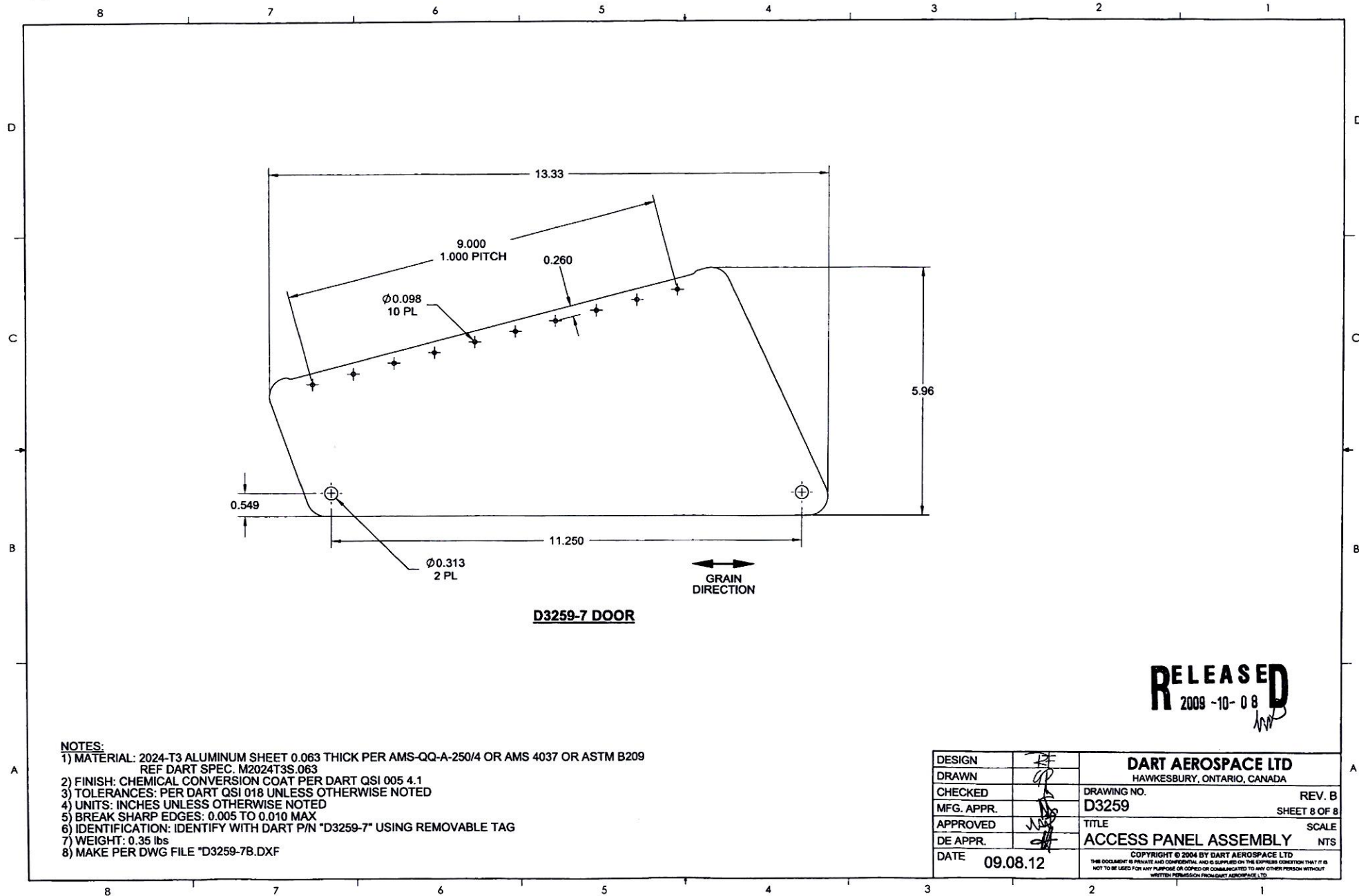
D3259-5 SPACER

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
- 7) WEIGHT: 0.07 lbs
- 8) MAKE PER DWG FILE "D3259-5B.DXF"

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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

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